

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027586**Date Inspected:** 29-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Watson Bowman Acme**Location:** 95 Pineview, Amherst NY**CWI Name:** Kevin P Sullivan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Expansion Joint Hinge A**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kevin Sullivan was present at the Watson Bowman Acme Corporation (WBA) facility, as requested in Amherst, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This QAI arrived at WBA and was informed that WBA would not be performing production welding on the SFOBB project today due Quality Control personnel for ABF is not on site.

This QAI performed random in process reviews of channel assembly SEI112667CA2-18. While performing these reviews it was noted that the fillet welds on this component appeared to meet the contract documents at the time of the review as outlined in drawing B-24952 sheet 5 of 12 Rev 12. This QAI also performed a random flatness check for the back plate and noted that the tolerance set by Caltrans design of 6mm maximum distortion had been exceeded and was at 10mm. This information was discussed with Quality Control Manager (QCM) Greg Ross who relayed that notification to Caltrans for heat straightening would be submitted for approval of this area before the heat straightening procedure was implemented for this area. The area where the tolerance was exceeded on SEI112667CA2-18 was approximately 500mm inward from each end plate (2).

During random observations it was noted that WBA welder John Ash was performing general cleaning of channel assembly SEI112667CA2-17 welds. The welder was observed as removing weld spatter, grinding minor deficiencies, and a general overall cleaning of the assemblies. It was also observed that WBA personnel was doing the lay out for the nelson studs required for this component on the bottom plate and back plate which require the 22mm x 100mm, AW108 anchor studs.

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Unless noted otherwise, all work observed on this date appeared to be in general compliance with the contract documents at the time of observations.

### Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and WBA Personell.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 858-531-0335, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Sullivan, Kevin	Quality Assurance Inspector
<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer

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